

Date: Thursday, 08/05/2008 12:38:21 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 39134		
Estimate Number	: 12740		
P.O. Number	:	Part Number	: D353523
This Issue	: 08/05/2008 S.O. No. :	Drawing Number	: D3535 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 08/05/2008 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 35218	Material	:
Written By	:	Due Date	: 23/05/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JUD 08.5.08</u>		
Comment	: Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 1.4296 sf(s)/Unit Total : 28.5915 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 107909 IB 8-5-9

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3535  
 Dwg Rev: B  
 Prog Rev: B

IB 8-5-9

2-Deburr if necessary IB 8-5-9

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-5-9

4.0	QC8	SECOND CHECK !!
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Comment: SECOND CHECK

5 08/05/12 (470)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326  
 2-Form joggle as per Dwg D3535 using Jig DT8158  
 3-Identify as D3535-23

IB 08/05/16 (20)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 08/05/2008 12:38:21 PM  
User: Julie Lecoq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39134

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/16 (420)

7.0

POWDER COATING

POWDER COATING



M 10 S 642



(20X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:30 PM

OVEN TEMPERATURE:

320 °F

FINISH TIME:

3:00 PM

M. 08/05/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-20

(420)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-15

MS

08-05-20

(420)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/21

Job Completion



MF 08-05-21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

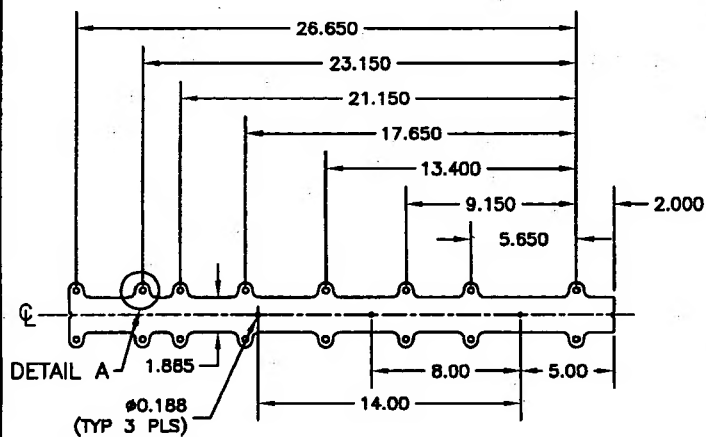
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

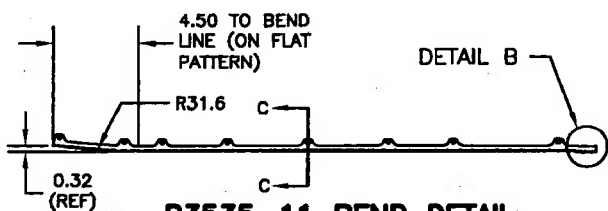
**DART**

RELEASED

07.04.24

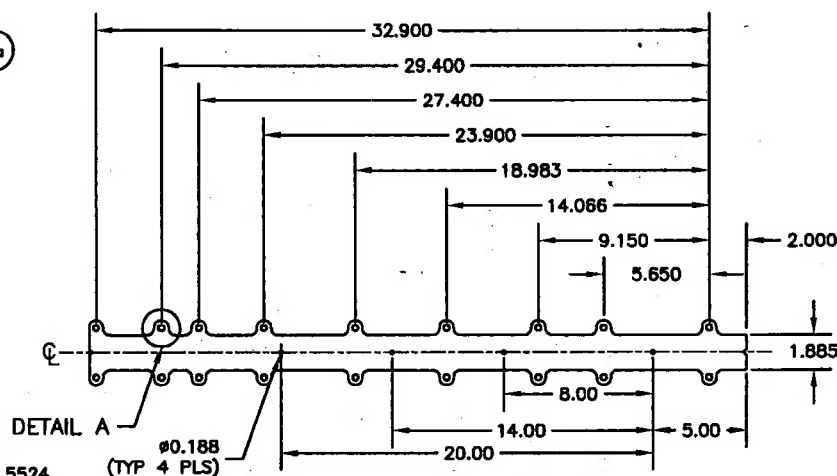


**D3535-11F FLAT PATTERN**

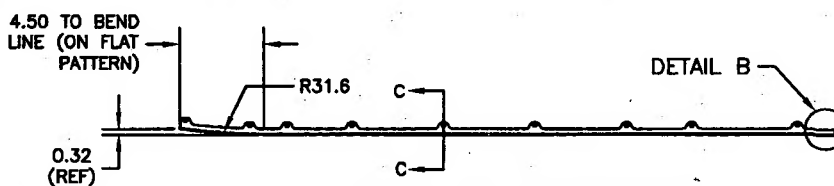


**D3535-11 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 39134



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

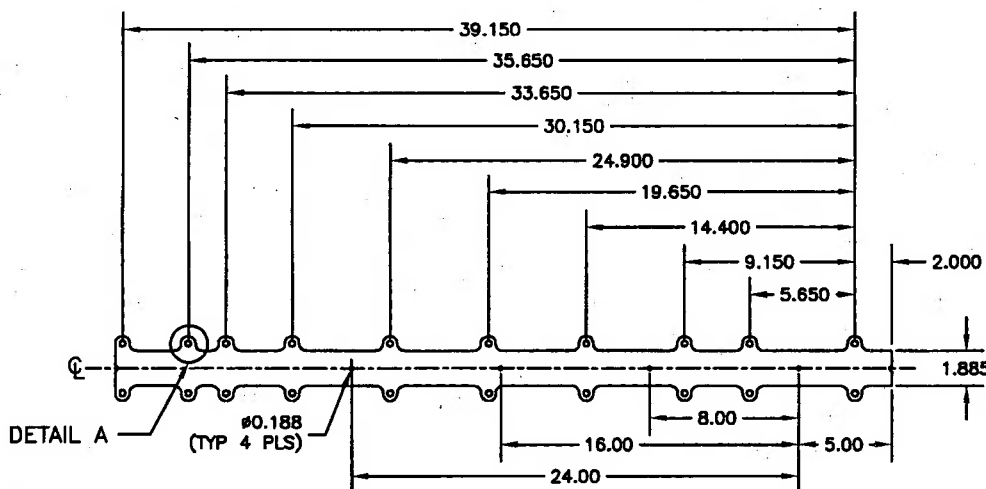
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

**DART**

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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
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		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



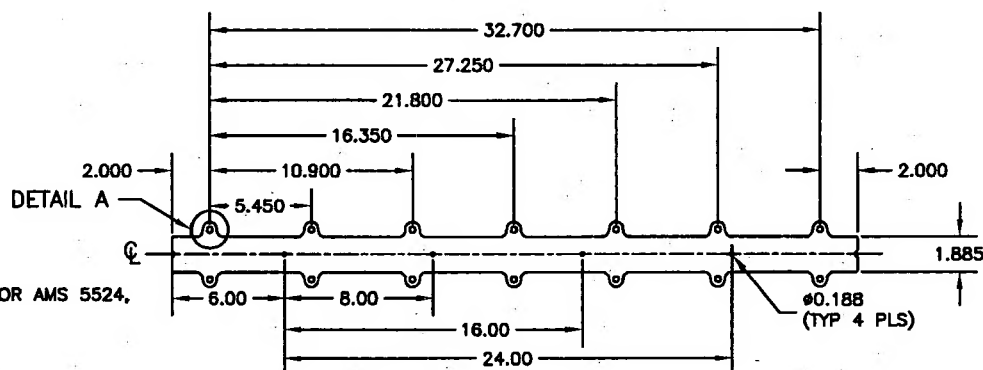
**D3535-15F FLAT PATTERN**

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

0.32  
(REF)

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WITHOUT NOTICE  
WORK ORDER  
NO. 336134

**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL**

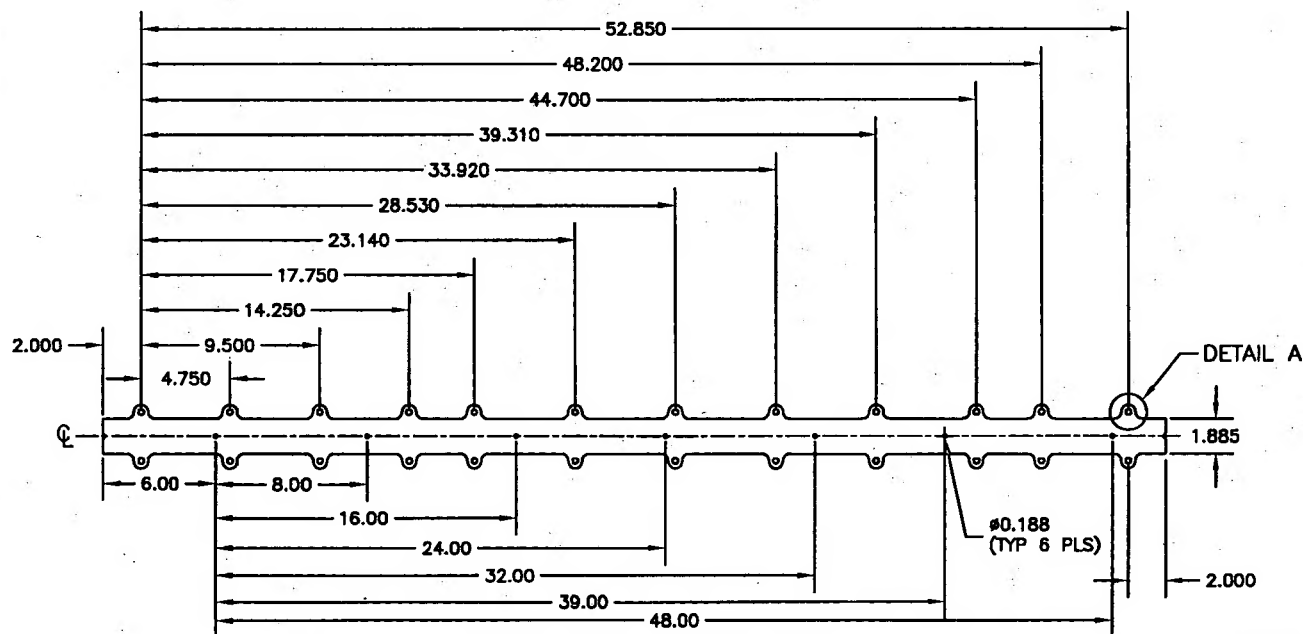
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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**DART**

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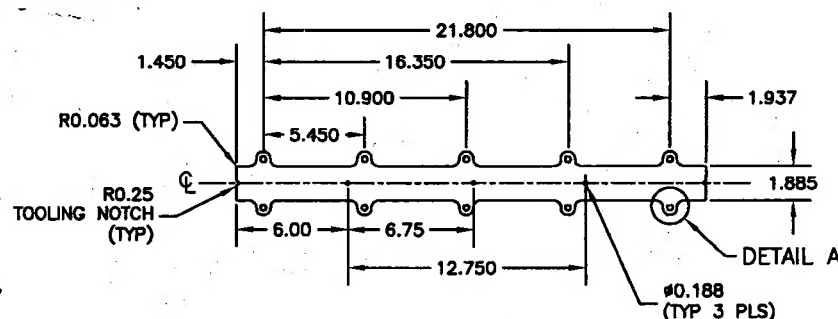
07.04.24



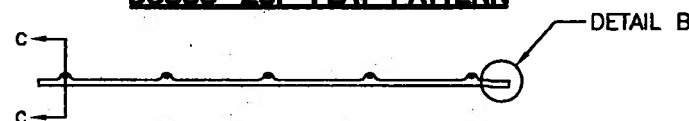
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NO. 51134

**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**



**D3535-25 BEND DETAIL**

**NOTES**

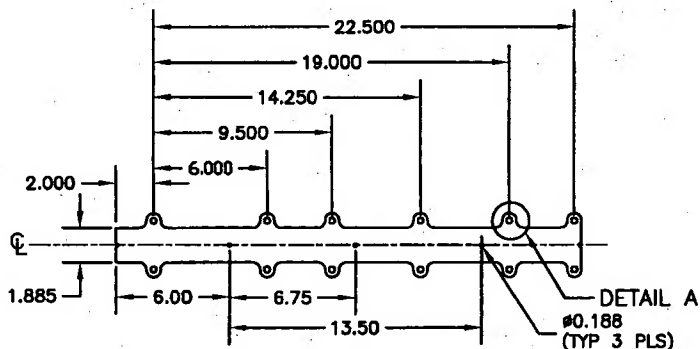
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
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		D3535	SHEET 3 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**DART**

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07.04.24

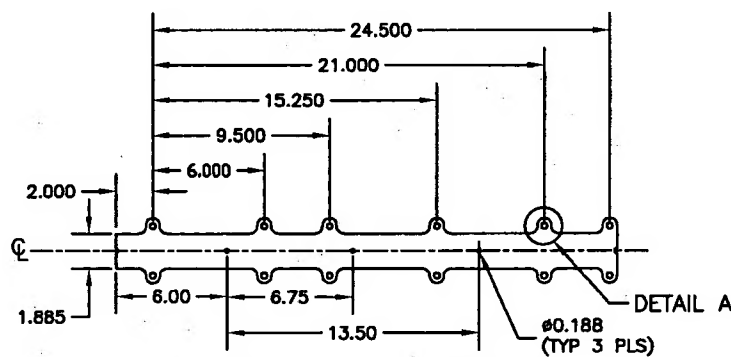
DESIGN <b>CB</b>	DRAWN BY <b>CH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 4 OF 7
	SCALE <b>1:10</b>	



**D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

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WORK ORDER  
NO. 39137

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
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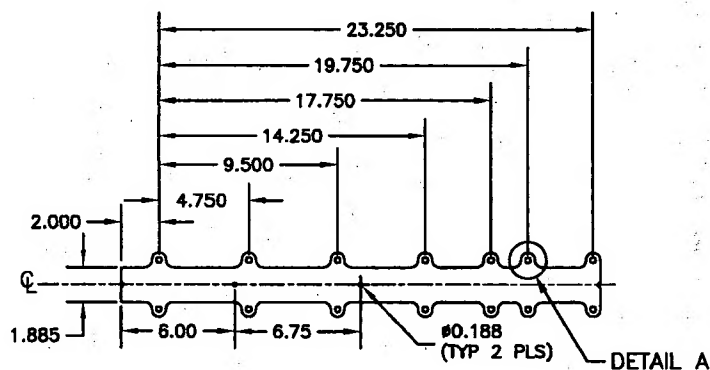




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07.04.17

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				REVISION
				SHEET 5 OF 7
				SCALE 1:10



D3535-35F FLAT PATTERN

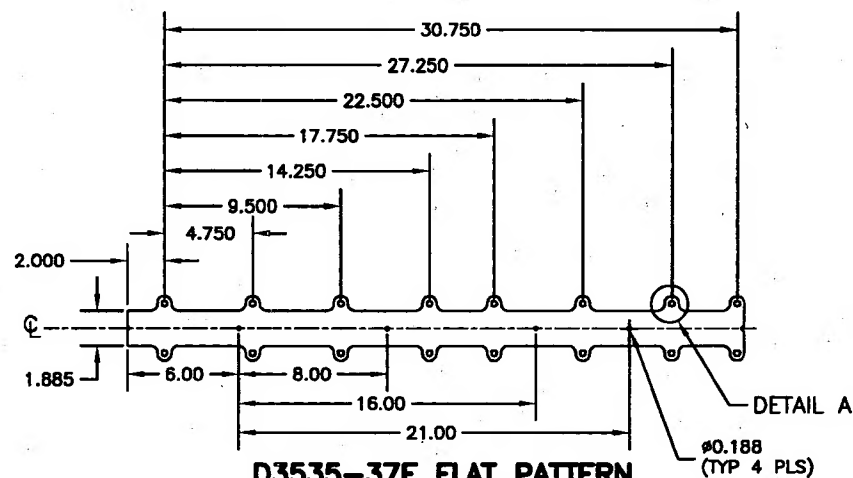


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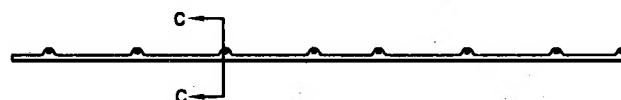
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39134

NOTES

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D3535-37F FLAT PATTERN



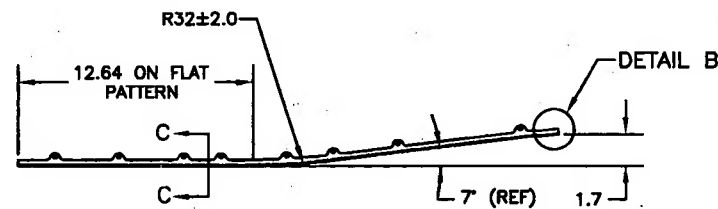
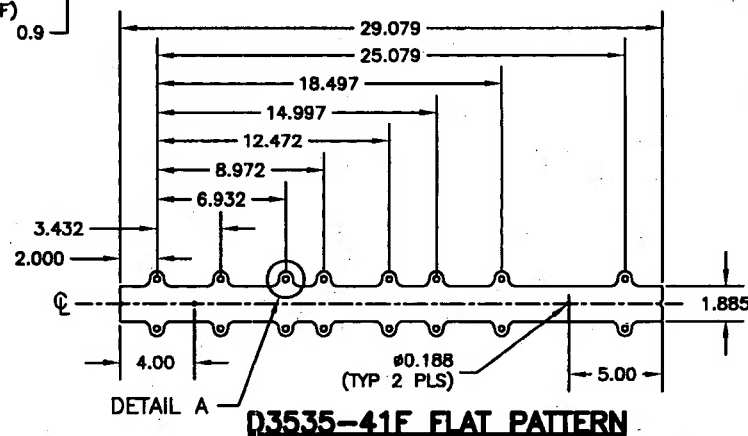
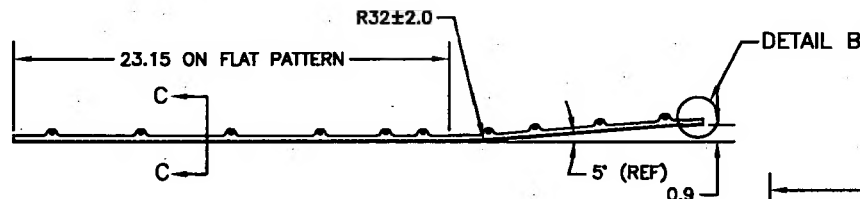
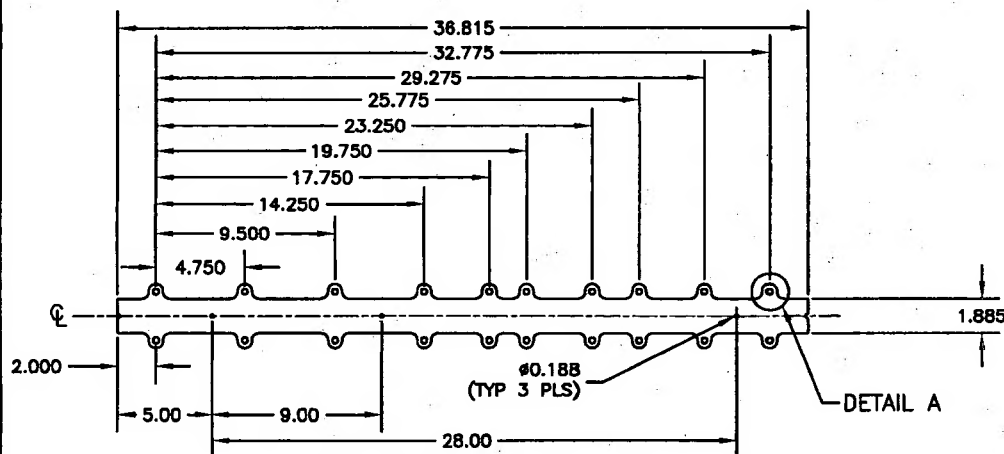
D3535-37 BEND DETAIL

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DATE		D3535
07.04.17		WEARSHOE
		SCALE
		1:10
		SHEET 6 OF 7
		REV. B



**NOTES**

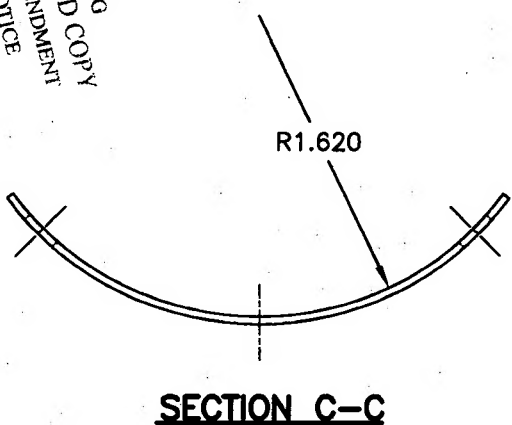
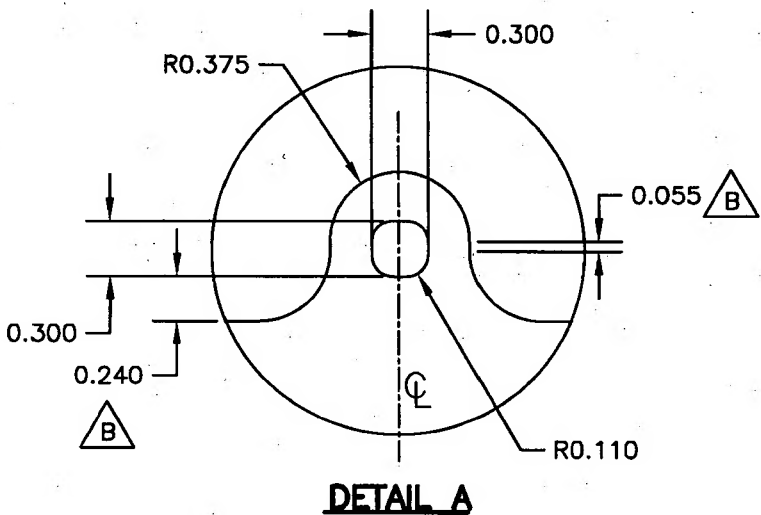
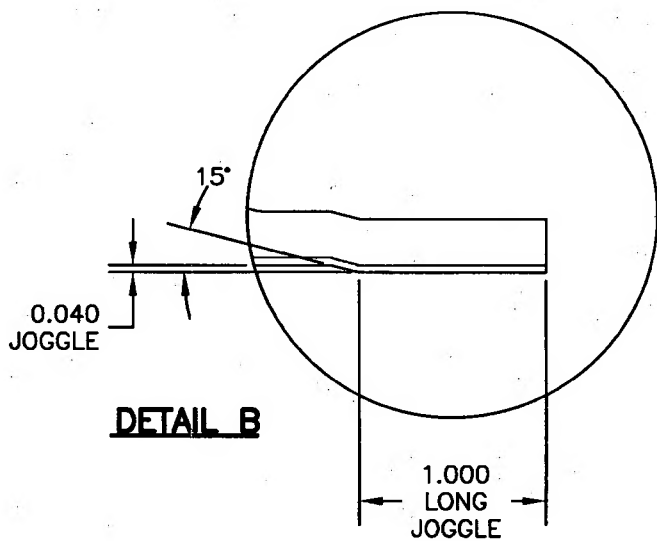
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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WORK ORDER  
NO. 34134

# DART

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07.04.17

DESIGN	C.B.	DRAWN BY	A.H.	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 7 OF 7
				SCALE 1:1



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WORK ORDER  
NO. 31137

DART AEROSPACE LTD		Work Order: 39134
Description: WEAR SHOE		Part Number: D3535-23
Inspection Dwg: D3535-23 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.191	*			
.300	+/- .010	.303	*			
.300	+/- .010	.303	*			
1.885	+/- .010	1.887	*			
2.000	+/- .010	2.000	*			
2.000	+/- .010	2.000	*			
4.750	+/- .010	4.751	*			
9.500	+/- .010	9.500	*			
14.250	+/- .010	14.250	*			
17.750	+/- .010	17.750	*			
23.140	+/- .010	23.140	*			
28.530	+/- .010	28.530	*			
33.920	+/- .010	33.920	*			
39.310	+/- .010	39.310	*			
44.700	+/- .010	44.700	*			
48.200	+/- .010	48.200	*			
53.850	+/- .010	53.850	*			
8.00	+/- .030	8.00	*			
6.00	+/- .030	6.00	*			
16.00	+/- .030	16.00	*			
24.00	+/- .030	24.00	*			
32.00	+/- .030	32.00	*			
39.00	+/- .030	39.00	*			
48.00	+/- .030	48.00	*			

Measured by: B
Date: 8-5-9

Audited by: [Signature]
Date: 08/05/12

Prototype Approval: [Signature]
Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	